

Date: Friday, 12/21/2007 7:27:40 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG EXTRUSION
Job Number : 36519	
Estimate Number : 10326	
P.O. Number : <i>N/A</i>	Part Number : D27317
This Issue : 12/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2731 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 34125	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 1/20/2008 Qty: 50 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total : 3.5858 f(s)

Lug Extrusion D2423

Batch: *B33310* *C207112121*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut D2423 extrusion to .82"

Batch: _____

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2731-7.

2-Check for crack while loading into the machine.

3-Tumble

4-Deburr any rough edges after tumbling

Issue to 5339

C207112121 (50)

Machine per drawing D2731 Rev. B

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

RG



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Receive + Inspect for transit damage

ensure C of C attached

12/21/11 (50)

5.0	QC5	SECOND CHECK
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Comment: SECOND CHECK

Inspect level 9

12/21/11 (50)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 08/01/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(50)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR

08-01-12

7.0

POWDER COATING

POWDER COATING



11 106379

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

BR

08-01-14

(50)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(50X)

Comment: INSPECT POWDER COAT

BR M-L

08/01/14

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 470

(overstock)

BR 08/01/15

(x50)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(50)

Comment: FINAL INSPECTION/W/O RELEASE

BR 08/01/15

Job Completion



BR 08-01-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

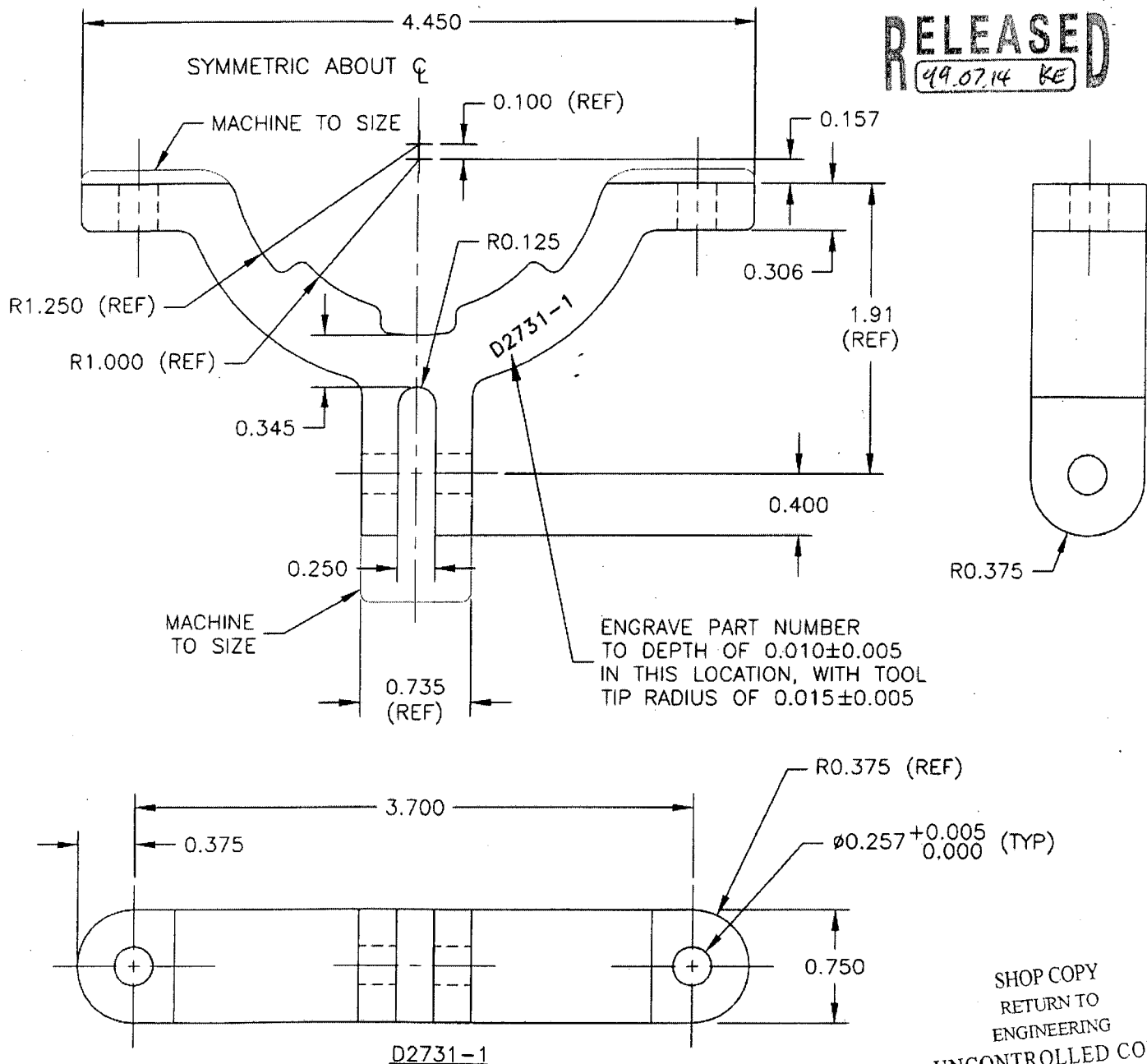
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



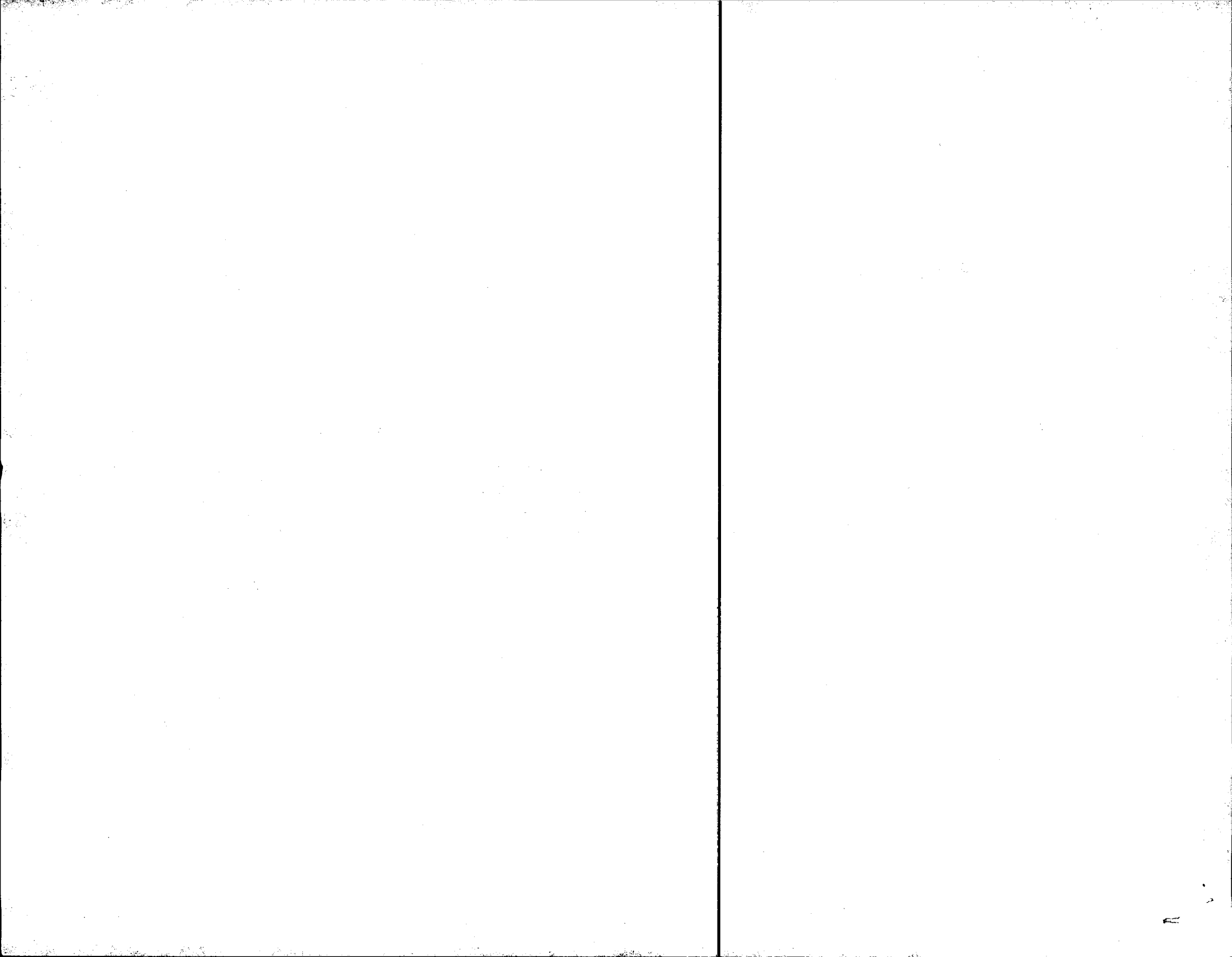
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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	

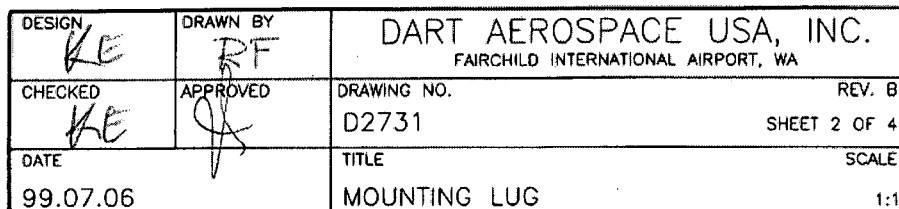


RELEASED
49.07.14 KE

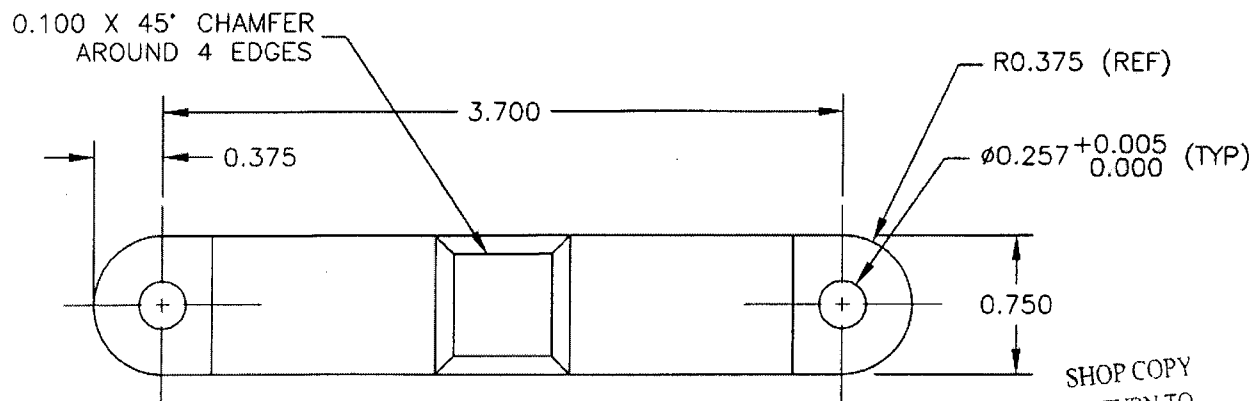
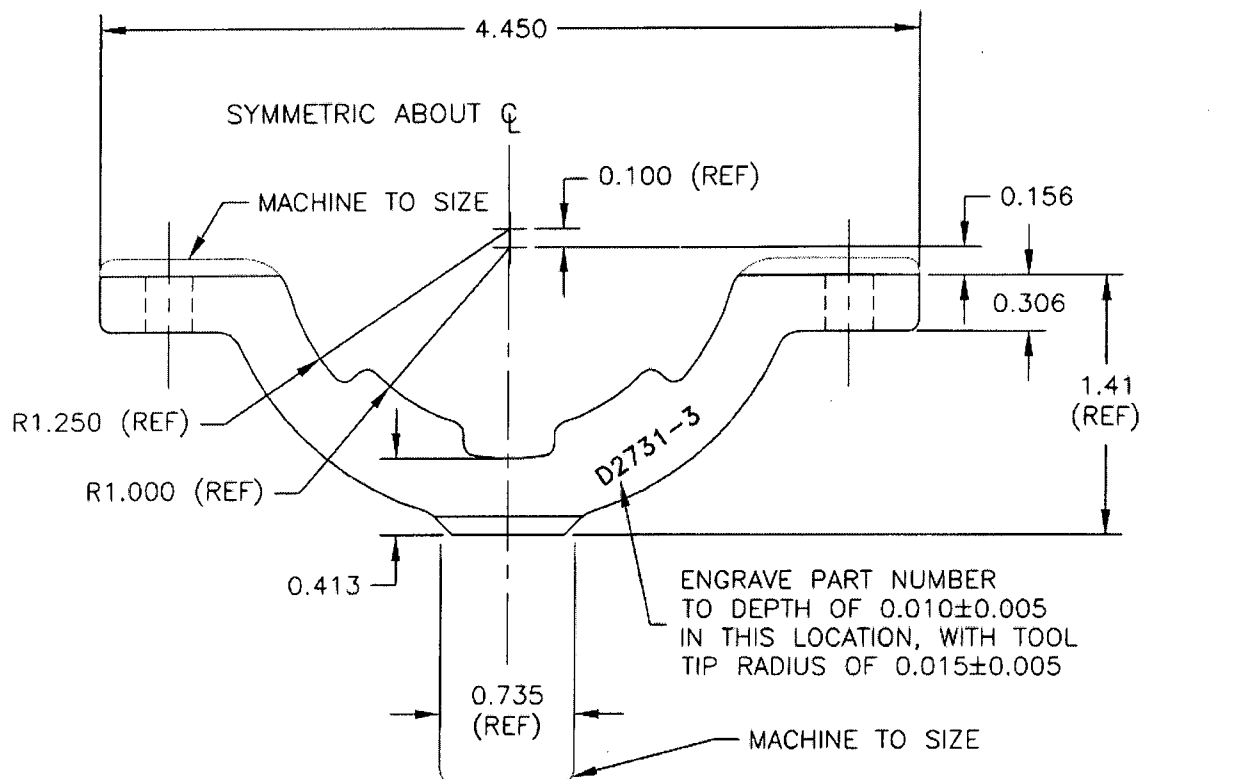
MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36519





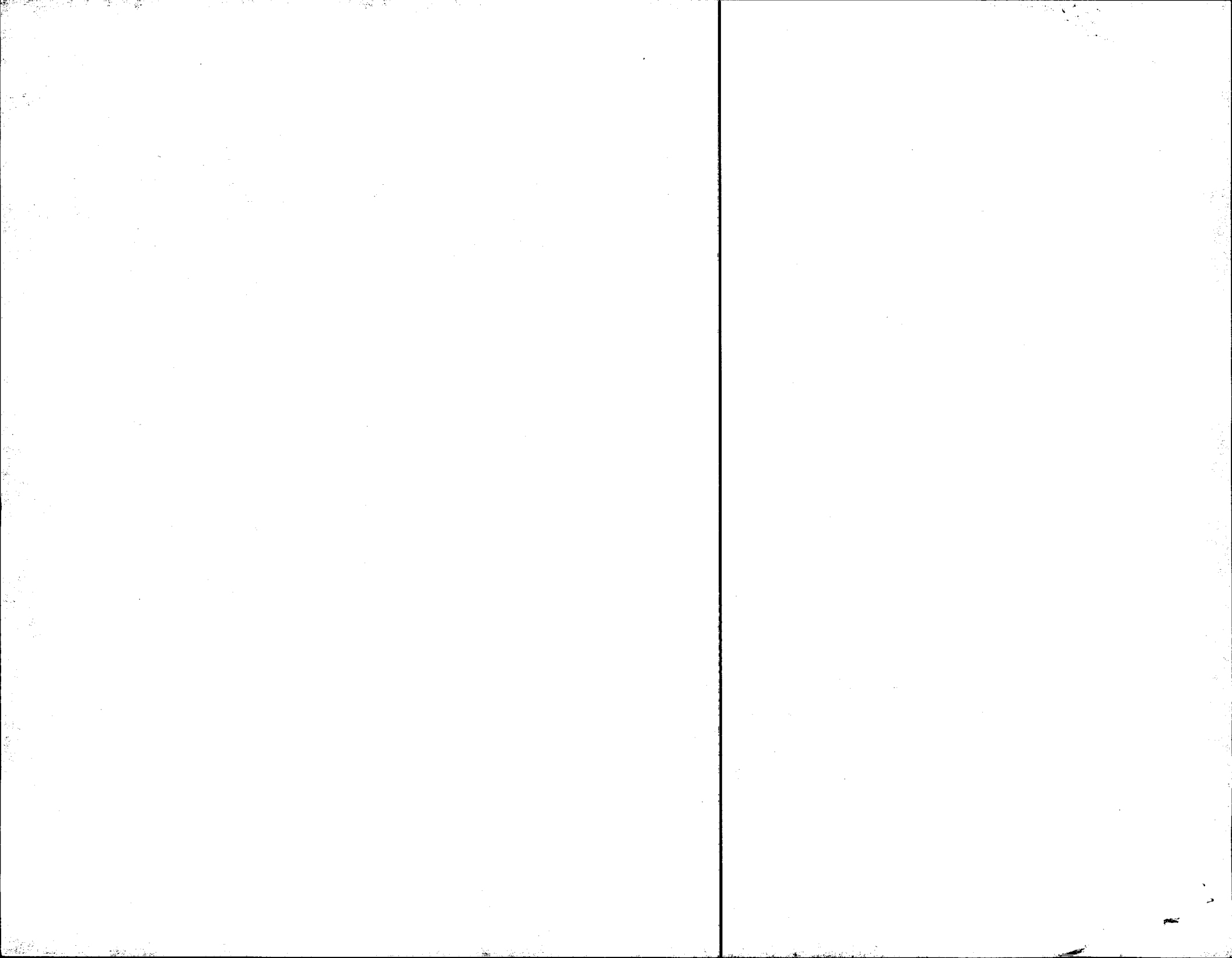
RELEASED
19.07.14 KE



D2731-3

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

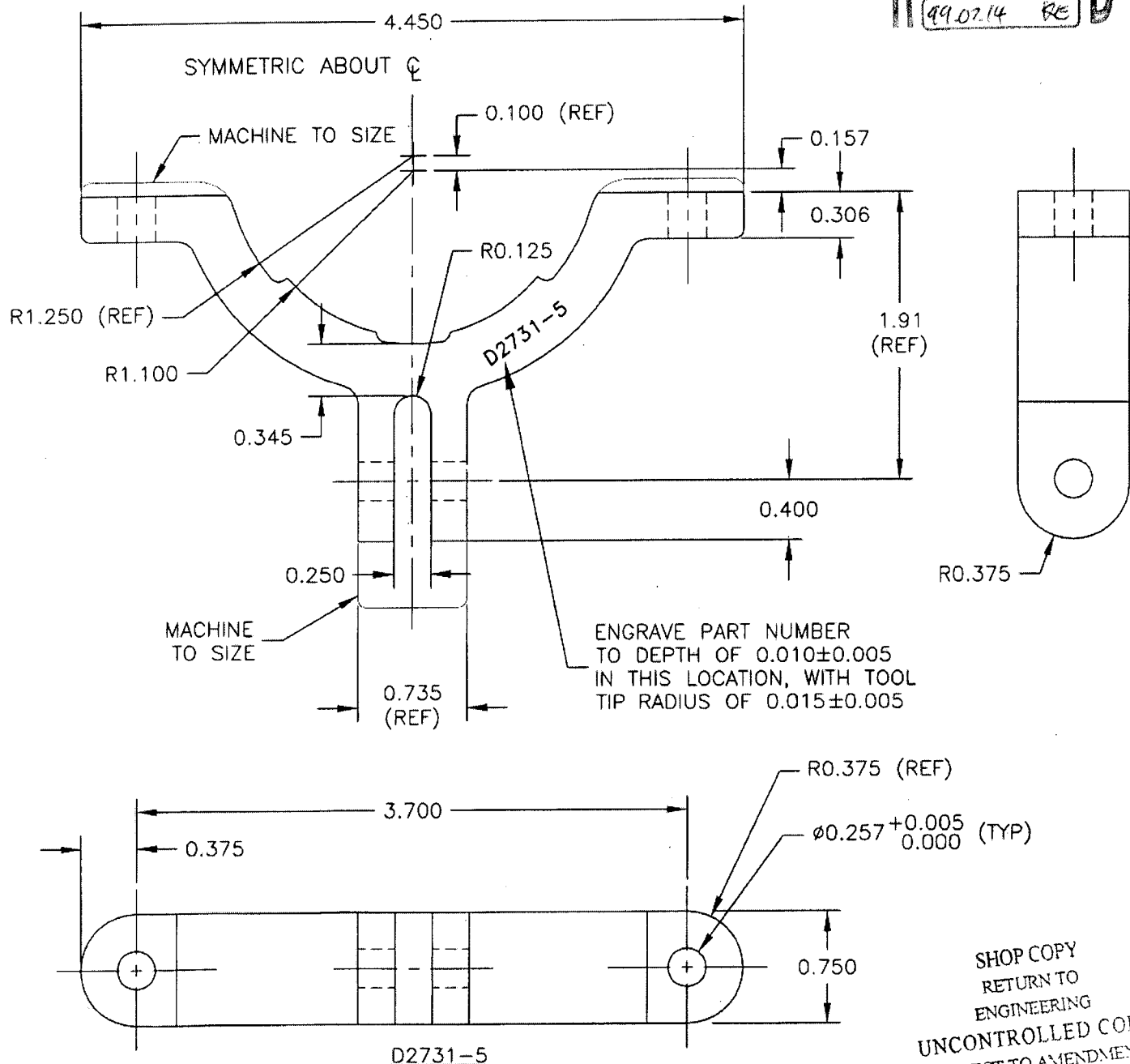
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36519





DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2731	REV. B SHEET 3 OF 4
DATE 99.07.06	TITLE MOUNTING LUG		SCALE 1:1

RELEASED
99.07.14 *RE*



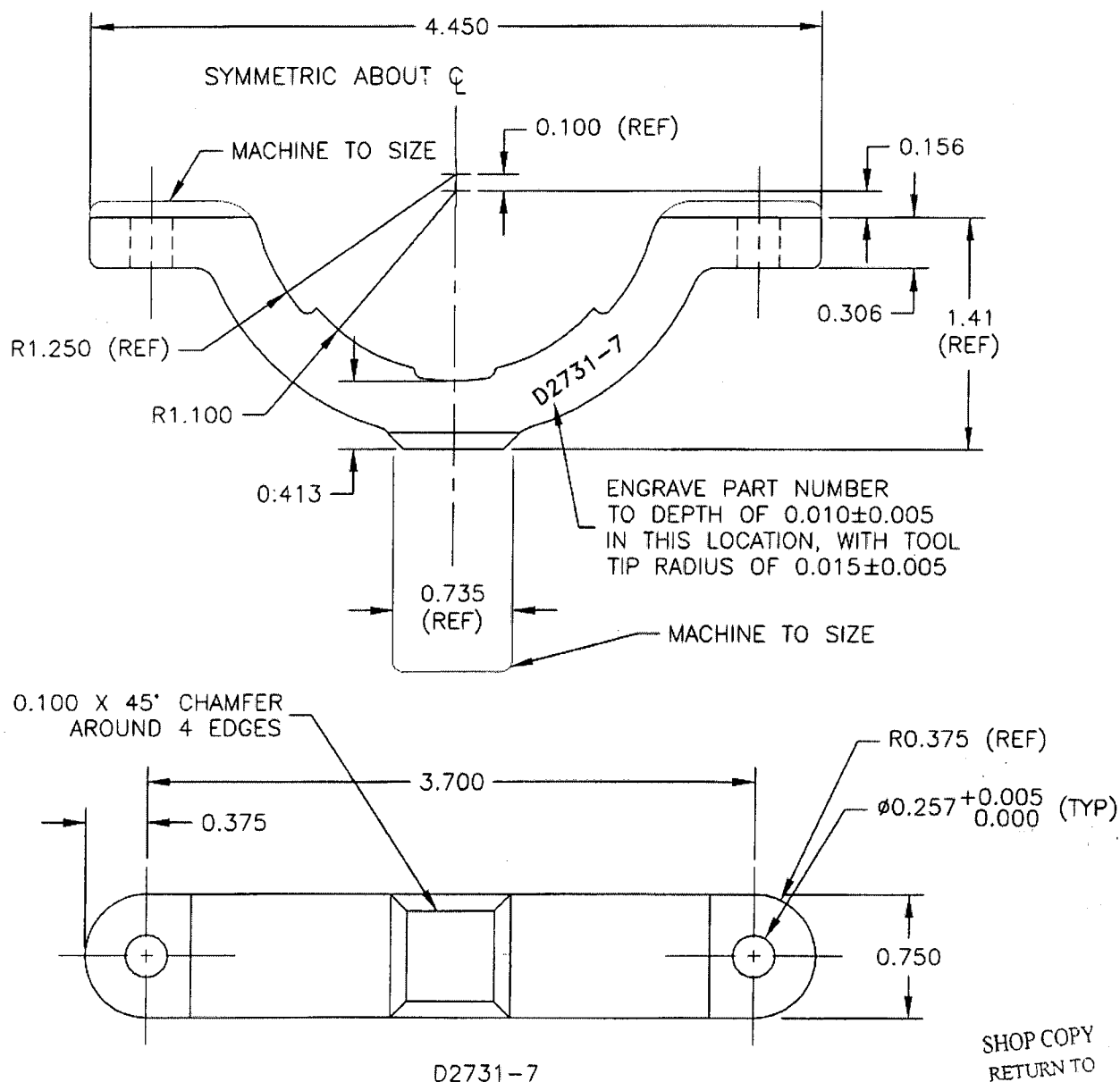
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BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
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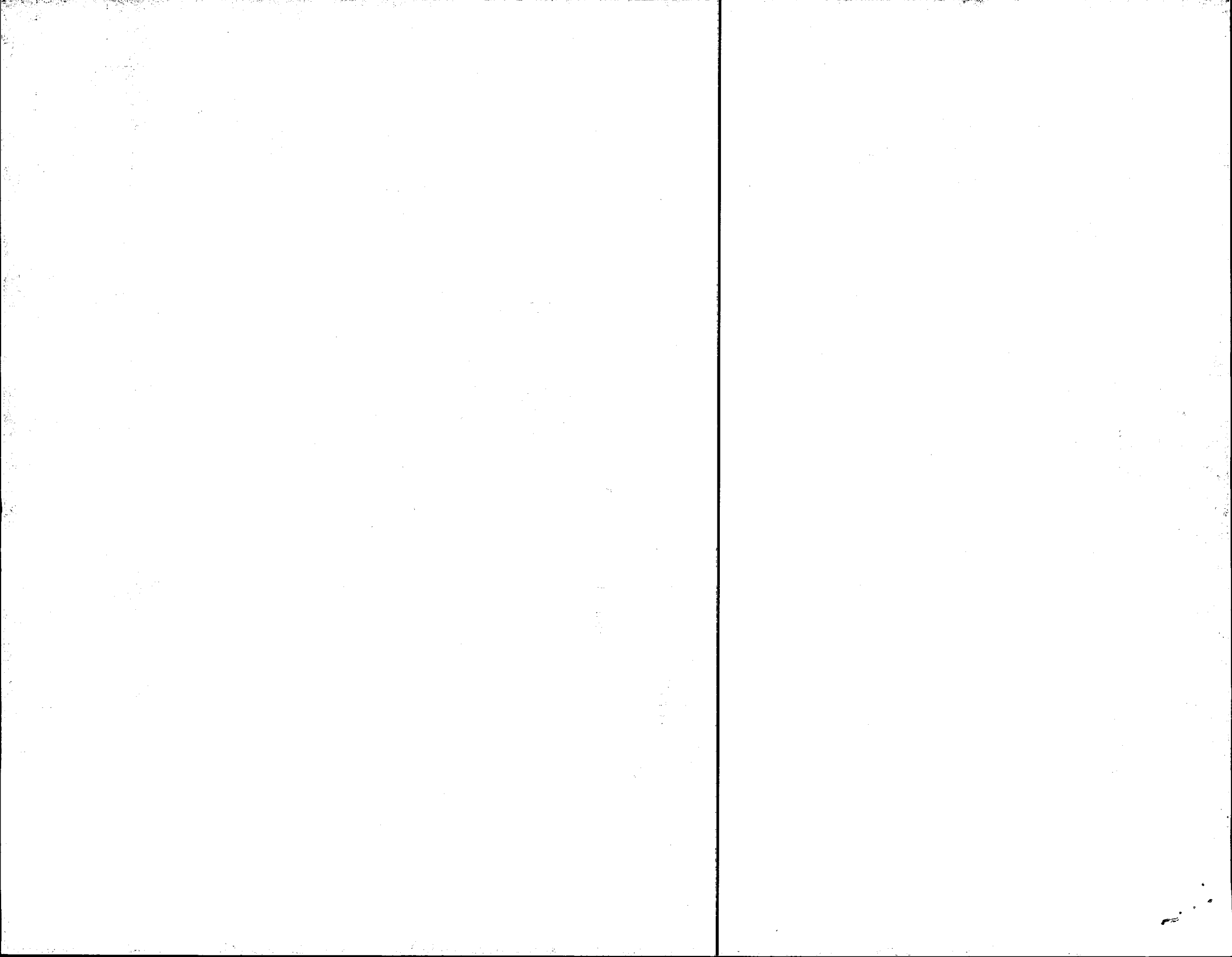
DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 *KE*



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
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WORK ORDER
NO. 36519





CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

50

D2731-7

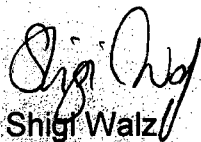
Lug B36519

P5339

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, January 9, 2008